

Work Order ID 58686

Friday, May 14, 2010 11:54:18 AM



Page 1

Item ID: D3535-13

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 5/14/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 5/20/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

PL

Date:

10514

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3535	Rev B								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3535, ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Debur if necessary

B10-5-25

(B)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B10-5-25

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8 10/10/26

(12)

PTG ->

Work Order ID 58686

Friday, May 14, 2010 11:54:18 AM



Page 2

Item ID: D3535-13

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 5/14/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 5/20/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Brake NC

NC BRAKE

Memo

0.00

Brake NC

1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326 2-Form joggle as per Dwg D3535 using Jig DT8158 Identify as D3535-13 88 10/05/06

(12)

140

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

S 10/05/07

(12)

150

0.00



Powdercoat

Grey Sandtex (Ref: 4.3.5.6) per QSI005 4.3

1112588

Memo

0.00

Powder Coating

START TIME: 7:15am OVEN TEMPERATURE: 745°F FINISH TIME: 320°F

J 10/05/08

12 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 58686

Friday, May 14, 2010 11:54:18 AM



Page 3

Item ID: D3535-13

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Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 5/14/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 5/20/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

12 R 10-5-28,

170

Identify as per dwg & Stock Location: FR-8

0.00



Packaging

Memo

0.00

Packaging

12 /

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/01 J
CY 10/5/28

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Friday, May 14, 2010 11:54:24 AM

Page 1

Work Order ID: 58686



Parent Item: D3535-13



Parent Item Name: Wearshoe

Start Date: 5/14/2010

Required Date: 5/20/2010

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM

Verified By:EC

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	---------------	----------------	--------

M304S20GA

Purchased

No

100

sf

185.3814

0.8505

12



1810-5-05

304/316 .040 Sheet

Location

Loc Qty

Loc Code

MAT

180.7278

114574

180.7278

114574

MAT20

4.6536

112885

3.1363

113062

1.5173

13

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	58686
Description: Wearshoe		Part Number:	D3535-13
Inspection Dwg: D3535 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.885	✓			
2.000	+/-0.010	2.000	✓			
5.650	+/-0.010	5.650	✓			
9.150	+/-0.010	9.150	✓			
14.066	+/-0.010	14.066	✓			
18.983	+/-0.010	18.983	✓			
23.900	+/-0.010	23.900	✓			
27.400	+/-0.010	27.400	✓			
29.400	+/-0.010	29.400	✓			
32.900	+/-0.010	32.900	✓			
Ø0.188	+0.005/-0.001	.192	✓			
20.00	+/-0.030	20.00	✓			
14.00	+/-0.030	14.00	✓			
8.00	+/-0.030	8.00	✓			
5.00	+/-0.030	5.00	✓			
0.300	+/-0.010	.300	✓			
0.300	+/-0.010	.301	✓			
0.038	+/-0.010	.033	✗			

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 10-5-25	Date: 10/6/26	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.15	New Issue	KJ/DD	DD

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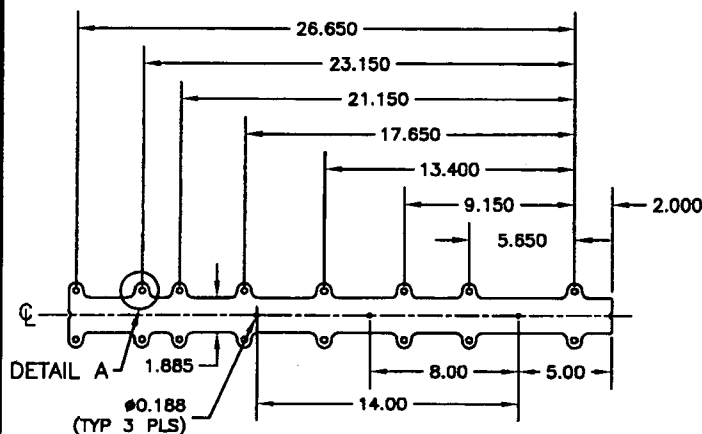
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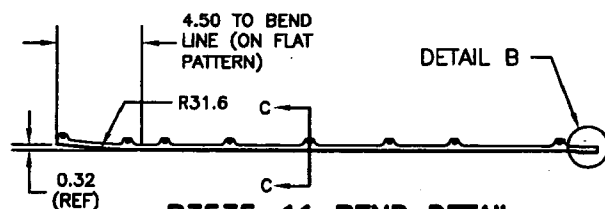
07.04.17

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58686

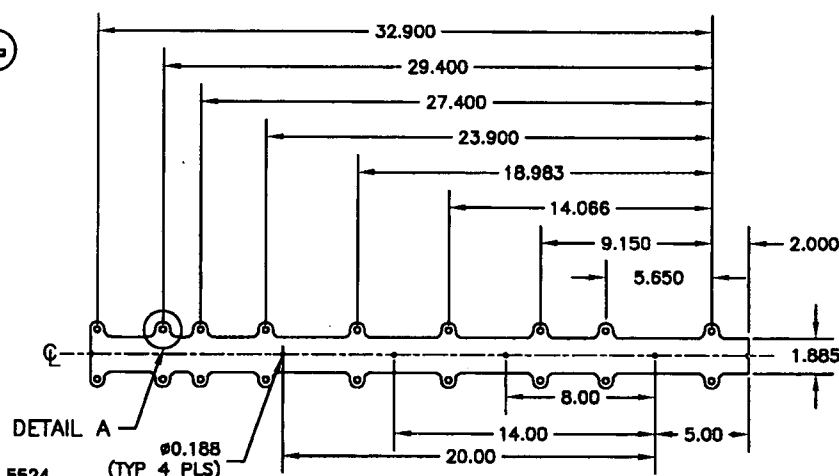
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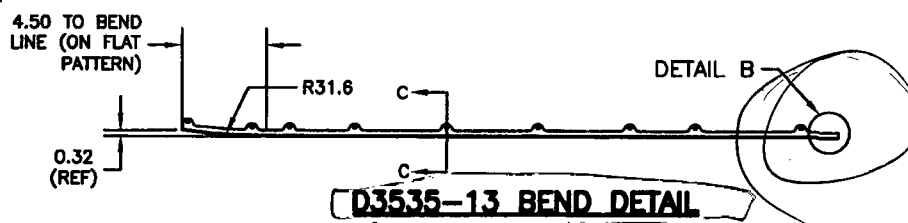
D3535-11F FLAT PATTERN



D3535-11 BEND DETAIL



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
DATE	DATE	TITLE
07.04.17	06.10.25	D3535
	07.04.17	WEARSHOE
		NEW ISSUE
		MOVE TAB OUTBOARD, ADD AMS SPEC
		SCALE
		1:10
		SHEET 1 OF 7
		REV. B

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

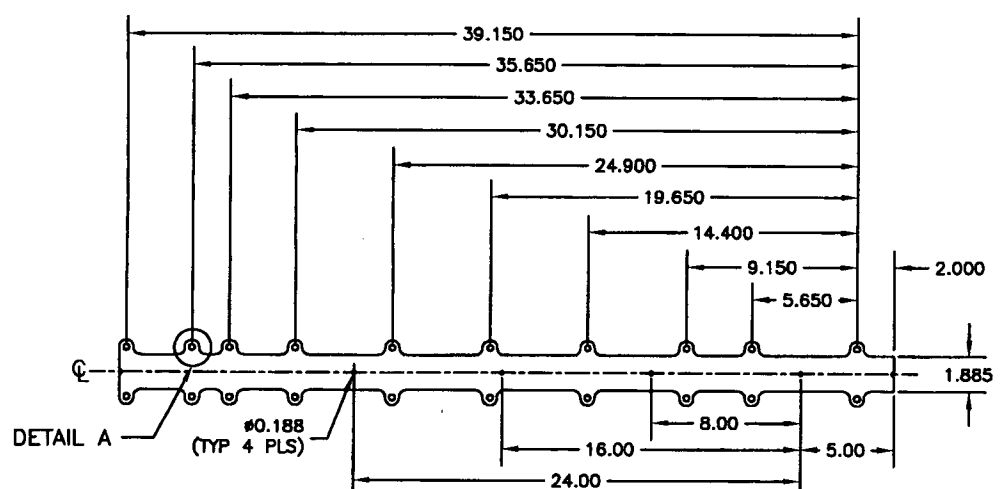
NOTE: Date & initial all entries

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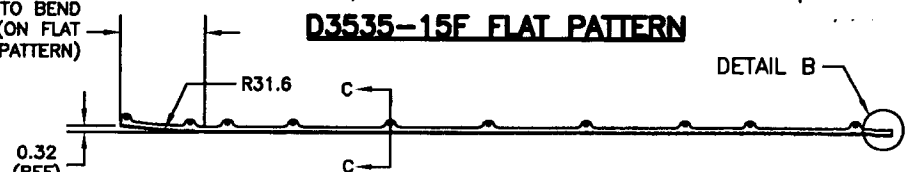
07.04.24

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DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 2 OF 7
		SCALE	1:10	



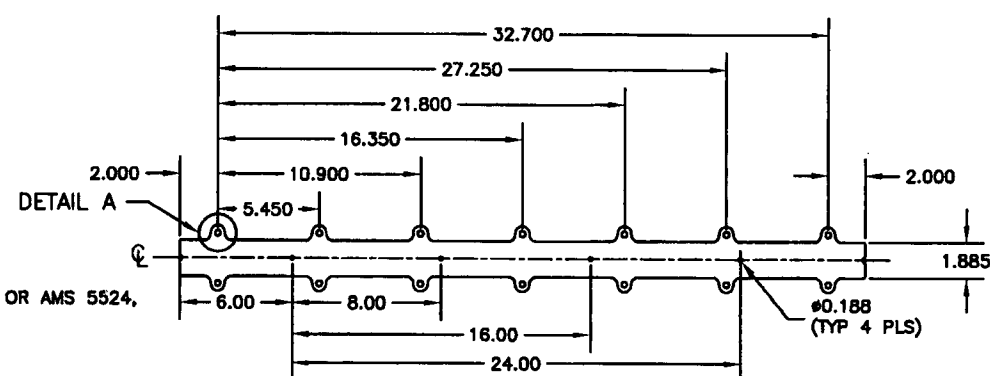
D3535-15F FLAT PATTERN

4.50 TO BEND
LINE (ON FLAT
PATTERN)

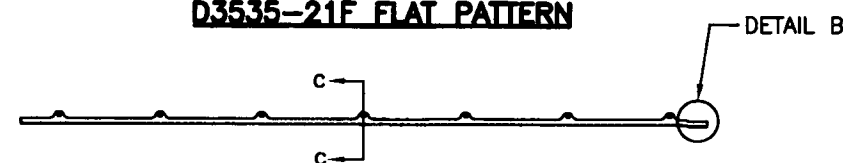


D3535-15 BEND DETAIL

w/o 58484



D3535-21F FLAT PATTERN



D3535-21 BEND DETAIL

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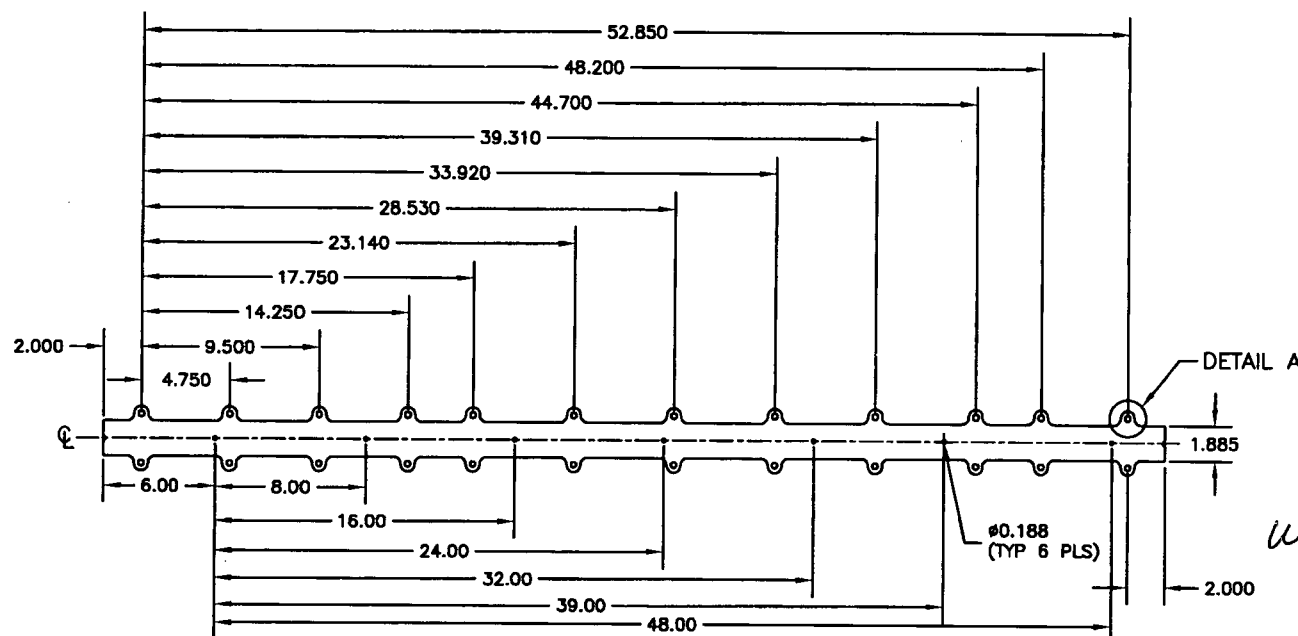
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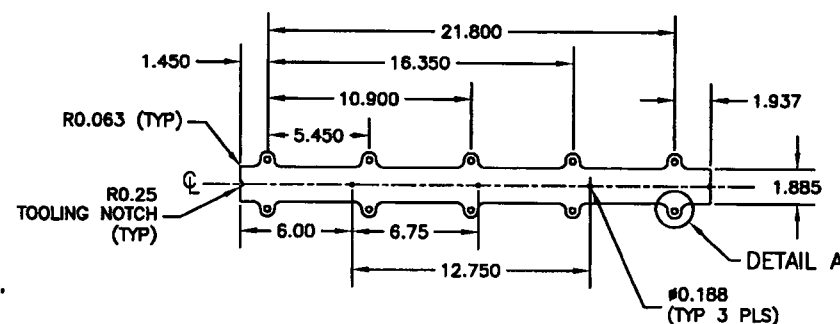
W1058684

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CHECKED		APPROVED		PORT HADLOCK, WA
DATE	07.04.17	TITLE	D3535	WEARSHOE
				SCALE
				1:10
				SHEET 3 OF 7
				REV. B



D3535-23F FLAT PATTERN

D3535-23 BEND DETAIL



D3535-25F FLAT PATTERN

D3535-25 BEND DETAIL

NOTES

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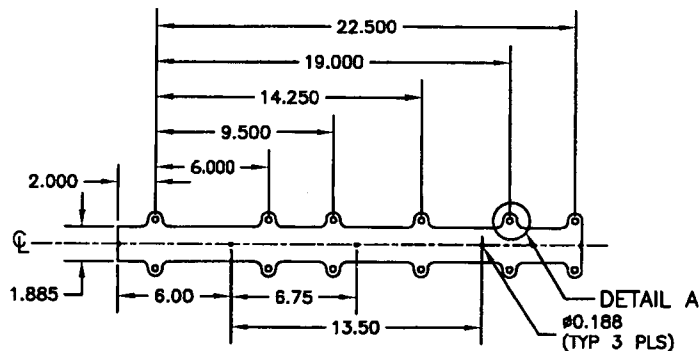
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DESIGN CB	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
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DATE 07.04.17	TITLE WEARSHOE	SHEET 4 OF 7
	SCALE 1:10	REV. B

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07.04.24

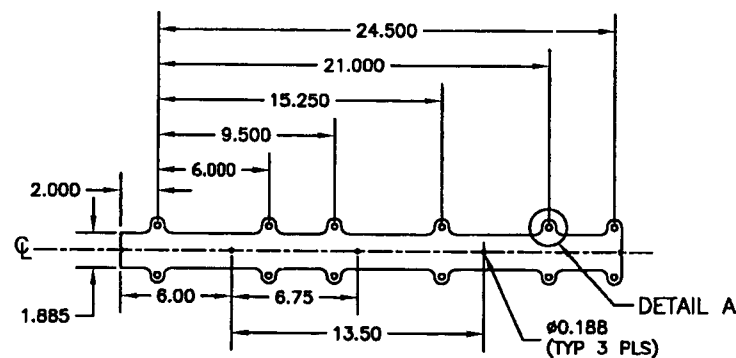
W1058684



D3535-31F FLAT PATTERN



D3535-31 BEND DETAIL



D3535-33F FLAT PATTERN



D3535-33 BEND DETAIL

NOTES

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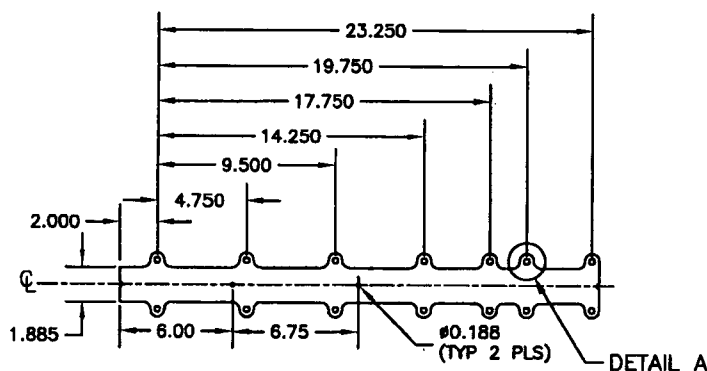
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07.04.17

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DATE	07.04.17	TITLE	D3535	WEARSHOE
				SCALE 1:10
				SHEET 5 OF 7
				REV. B

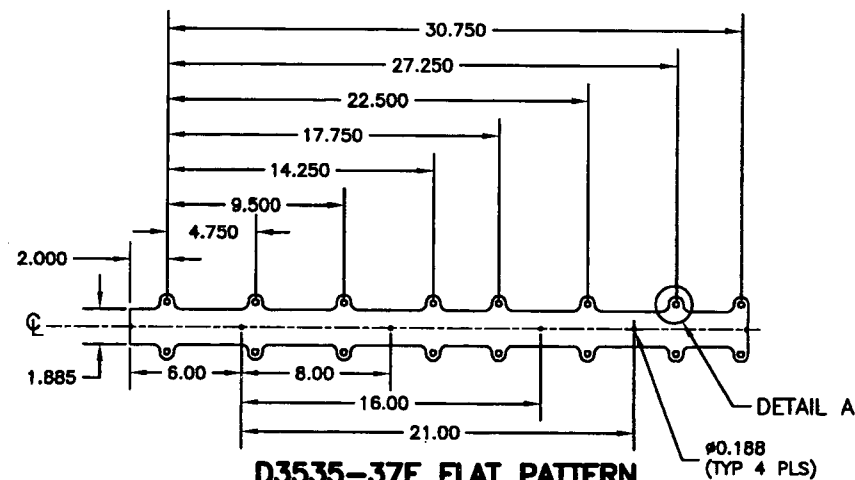


D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL

w/o 58686



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

NOTES

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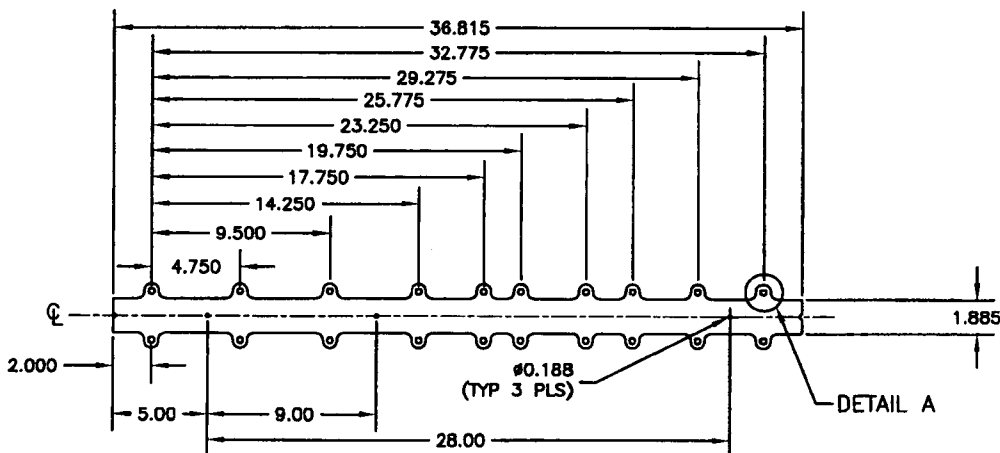
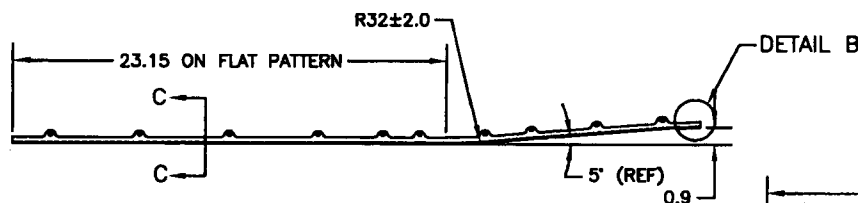
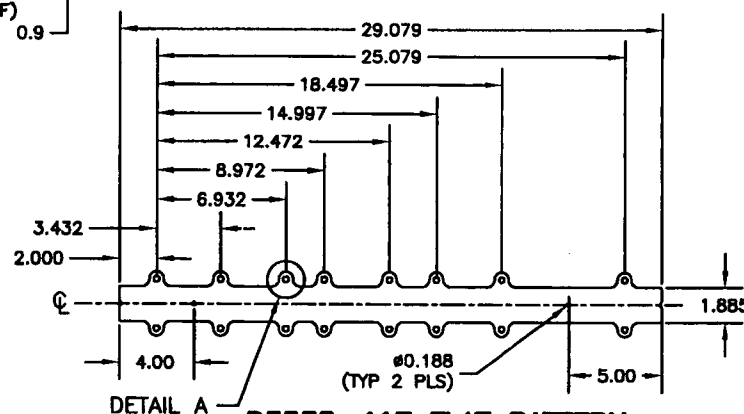
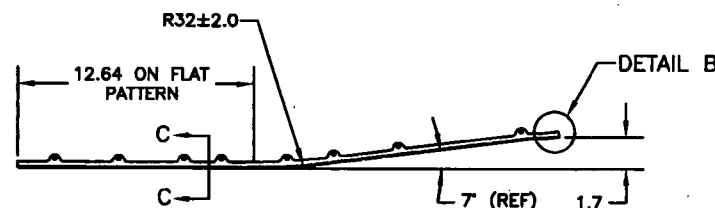
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DARTRELEASED
070424

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. B
<i>[Signature]</i>	<i>[Signature]</i>	D3535	SHEET 6 OF 7
DATE	TITLE	WEARSHOE	SCALE
07.04.17			1:10

**D3535-39F FLAT PATTERN****D3535-39 BEND DETAIL****D3535-41F FLAT PATTERN****D3535-41 BEND DETAIL****NOTES**

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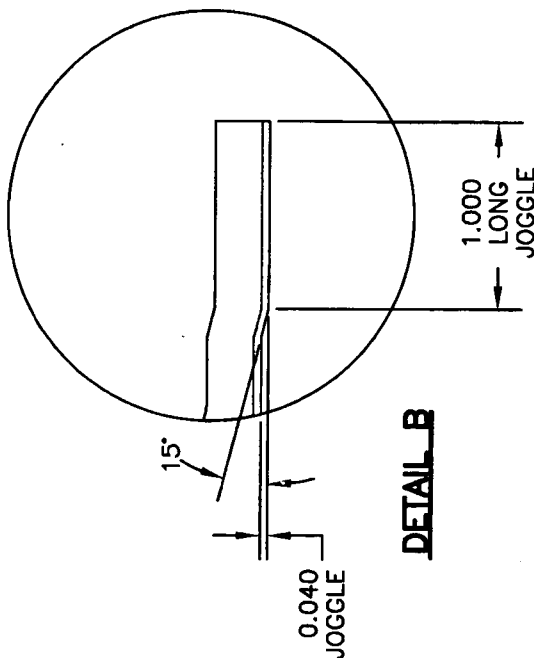
NOTE: Date & initial all entries



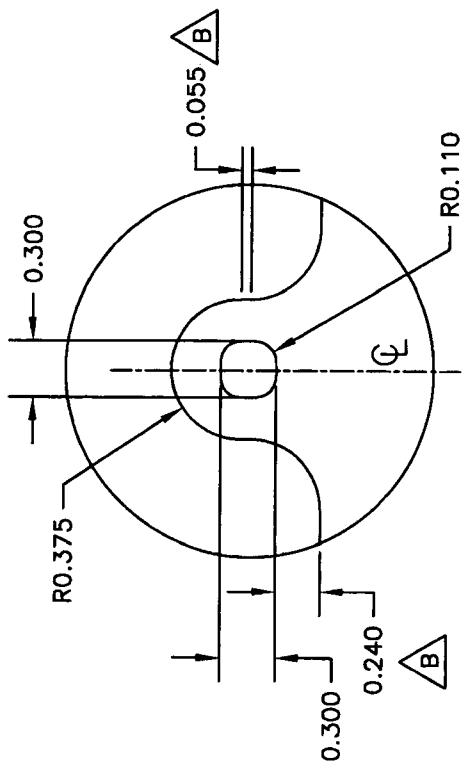
DESIGN CB	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 	APPROVED 	DRAWING NO. D3535	REV. B SHEET 7 OF 7
DATE 07.04.17	TITLE WEARSHOE		SCALE 1:1

RELEASED

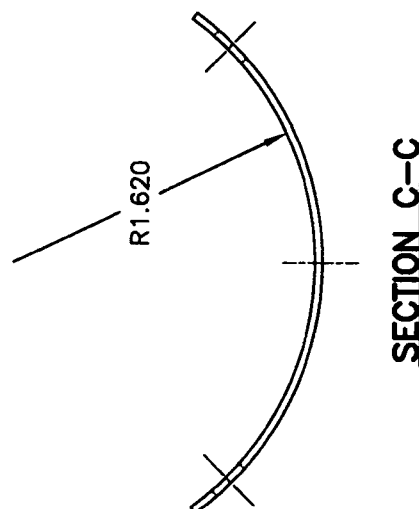
07.04.24



DETAIL B



DETAIL A



SECTION C-C

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries